

Work Order ID 153081***153081***

Page 1

Tuesday, November 08, 2016 10:52:00 AM

Item ID: D5388-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stub Cover

Start Date: 11/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/8/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: NOV 09 2016

Tooling:

Date:

Run Start

NR1QC: 9-89

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5388

A

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D5388

Dwg Rev: AProg Rev: A

2-Deburr as required

0.00

4

DAS
46
9-89

16/11/14

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

4

DAS
46
9-89

16/11/14

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[illegible]

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Page 3

[illegible]

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Page 4

Powdercoat
Powder Coating

OVEN TEMP: 210
START TIME: 3:00
FINISH TIME: 2:40

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153081

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Item ID: D5388-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stub Cover
Start Date: 11/8/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/8/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							DAS 38 9-89
220						4			
QC	Memo	0.00							
Quality Control									JAN 10 2017
230	Identify as per dwg & Stock Location: 5-224B	0.00							
230						4			JAN 11 2017
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							JAN 13 2017
240									
QC	Memo	0.00							
Quality Control									JAN 13 2017

DAS
21
9-89 JAN 11 2017

Picklist Print

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Work Order ID: 153081

153081

Parent Item: D5388-1

D5388-1

Parent Item Name: Stub Cover

Start Date: 11/8/2016

Required Date: 11/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 16-02-26 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No			sf	174.3100		3.51579			
M6061T6S 063									**			DAS 46 9-89	16/11/14
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

174.31

M133511

2.6

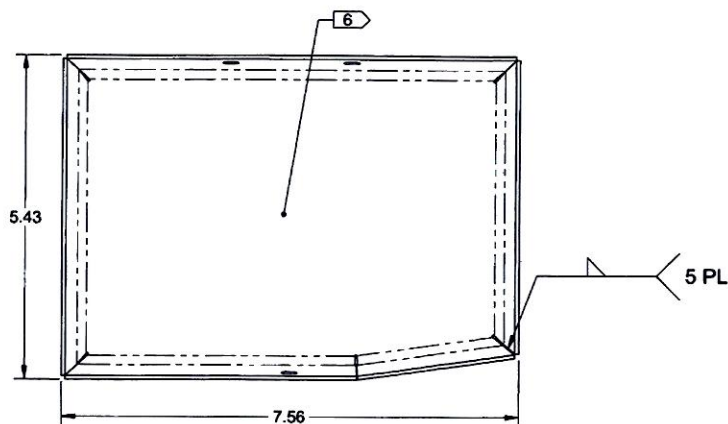
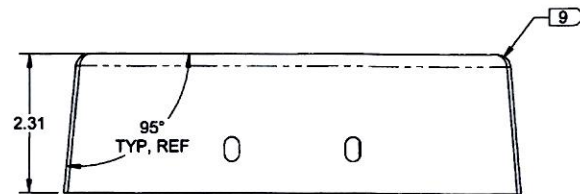
M134377

3.3

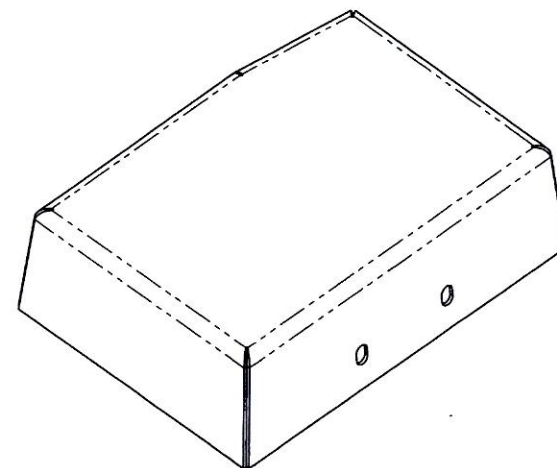
M134830

168.41

4.1



D5388-1 STUB COVER
(MAKE FROM D5388-1F)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153081 MJS
16-11-09

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.54 lbs
- 8) WELDING: PER DART QSI 004
- 9) BEND RADII: R0.16 TYP

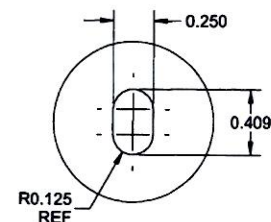
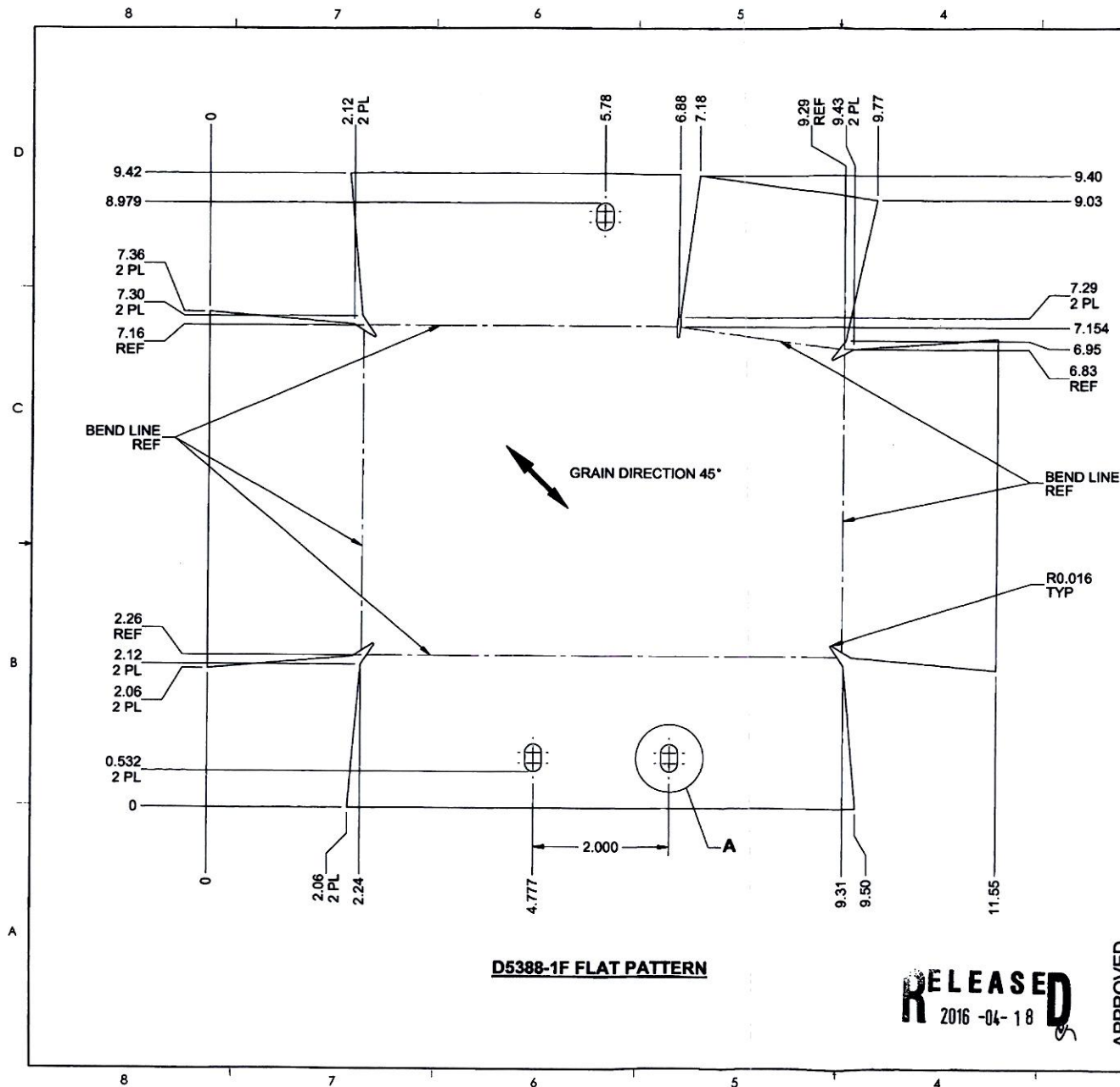
RELEASED
2016-04-18
CEN 16-562

APPROVED

A NEW ISSUE		MB	16.02.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	MB		
CHECKED	AJS		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	16.02.18		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D5388	SHEET 1 OF 2
TITLE	STUB COVER	SCALE
		NTS

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DETAIL A: SLOT DETAIL
3 PL, SCALE 2X

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC M6061T6S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.54 lbs
 - 8) ALL NON DIMENSIONED FEATURES PER CAD FILE
D5388-1F-REVA .DXF

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5388	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STUB COVER	NTS
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